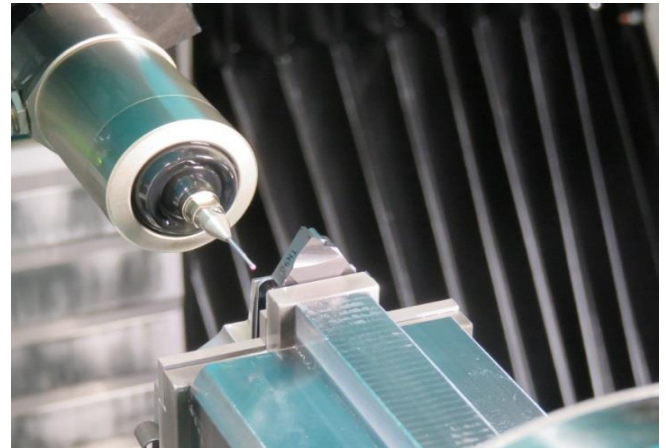
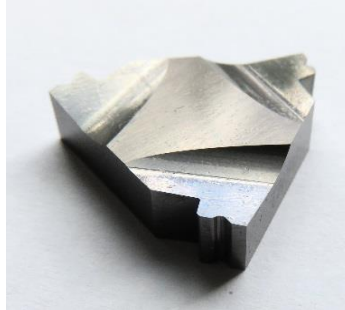













Insert 6204 Z3 IDØ12.7

A08-200

Pregrinding of the corner uses a 1A1 and is executed in 2 plunges. Finishing of the profile uses standard profiling process with pointed wheel. The chipbreaker is executed in oscillation mode generating the bottom radius of 3 mm. The below mentioned cycletime is per side.



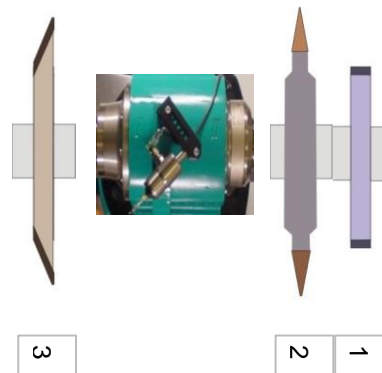
1. Cycletime for Production

| | | | | | | |
|--|---|---|---|---|---|---|
| Workpiece: Triangle IDØ 12.7 T4.76 Material CERMET | | | | | | |
| Operations |  |  |  |  |  |  |
| | Probe | Pregrinding | Finishing | Polishing 1 | Polishing 2 | Chipbreaker |
| Feed [mm/Min] | 2000 | 5 | 6 | 15 | 22 | 2400 |
| Power [kW] | | 4 | 3 | 2 | 2 | 2 |
| Cutting speed [m/s] | | 20 | 20 | 20 | 20 | 20 |
| Used wheels | |  |  |  |  |  |
| | | 1 | 2 | 2 | 2 | 3 |
| Grinding time [s] | 18 | 120 | 118 | 53 | 37 | 139 |
| Total cycle time | 8 Min 5 | | | | | |

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

| | |
|---|--------------------|
| 1 | 1A1 Ø125 D64 MH |
| 2 | 14EE1 Ø200 D46V20° |
| 3 | 1V1 Ø180 D54 |



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NGS
Control: Fanuc 31iB 5
Accessories: RPC
Responsible engineer: OP, 13.7.16

Coolant: Synthetic Oil, pressure 6 bar
Software: Quinto 5

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J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland
Subsidiaries in: France, Deutschland, Italia, United States, China